Work Order ID 103618 \*103618\* Page 1 June-24-13 1:59:27 PM Accept Item ID: D4148-041 \*N900040100\* Setup Start **Revision 1D:** Item Name: FWD X-TUBE LUG ASS'Y Start Qty: 1.00 **Start Date:** 6/24/13 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 6/24/13 **Customer:** Reference: Run Process Plan: MLS Date: 13-06-25 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Qty Run Hours Code Otv Number Stamp **Revision Nbr** Draw Nbr D4148 100 0.00 \*100\* Small Fab 0.00 Memo Small Fab 1- Assemble as per dwg DAS 27 110 QC5- Inspect part completeness to step on W/O \*110\* Memo Quality Control 120 Identify as per dwg & Stock Location: 0.00\*120\* Packaging 0.00 Memo

Packaging

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order ug	odate only	AEROSPACE		
					DISPOSITION			AGAINS'		PARTMENT				
Work Order	ri:					, ]			_	7		<b>-</b> <del></del>		
Part No	0.				Rework Scrap			Skid-tube Crosstube Machining Small Fal	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality		
					Use-as-is		Therr	moforming Finishin	g	Rec/Sto	re/Packaging	Other		
NCR No	0				Suspected Unapproved			Large Fab Composite	e 🗀	]	Supplier			
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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	Bending			<u> </u>	Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
	Centre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up		
L	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure		
L	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
ļ.,	Cuffs			Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
	Crushing Count			Countersink		Misalig	gned/off center		Positioned V	Vrong	_			
	Heat Treat Cut Too Short			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
	Inspection Strip in Tube Drawing			Drawing		Misread	d							
	Marks/Ch	natter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of	Calibration						
	Wave/Tw	rist in Tub	e		Fit/Function		Out of :	Sequence		-				

Work Order ID 103618 \*103618\* Page 2 June-24-13 1:59:27 PM Item ID: D4148-041 Accept \*N900040100\* Setup Start Revision ID: Stop Item Name: FWD X-TUBE LUG ASS'Y \*1\* Start Qty: 1.00 Start Date: 6/24/13 Cust Item ID: Required Date: 6/24/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Date: Tooling: Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: QC: Sequence ID/ Tool # Plan Reject Insp. Operation Set Up/ Tool ID Accept Reject Work Center ID Description Qty Qty Number Stamp Code **Run Hours** QC21- Final Inspection - Work Order Release 0.00 130 MUS 13-08-23 \*120\* QC 0.00 Memo Quality Control

DQA:		Date	:										TART
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	Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorr	ect		Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/N	/lissing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Move	d	Ш	Wrong Stock Pulled
Crushing			Countersink		Misalig	gned/off center		Positioned	Wrong				
			Cut Too Short		Mislabe	eled		Power Loss	s/Surge		Other		
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	]Mar!	cs/Chatter			Drill Holes		Off-set						
	Turn	ing Sequenc	e		Finish		Out of	Calibration					
	Wav	e/Twist in Tu	ıpe		Fit/Function		Out of	Sequence					<del></del>

Page 1

Work Order 1D:

103618

Parent Item:

D4148-041

Parent Item Name:

FWD X-TUBE LUG ASS'Y

Start Date: 6/24/13

Required Date: 6/24/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

IPP Rev:C 10.10.29 as per revC

DD verf:EC

IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date. Issued	Status
MS21043-3		Purchased	No			100	Each	1,437.0000	4	2	ノノベ	. 7/2	2/-
Nut											<u></u>	<u> </u>	8/22
				Location		Loc Qty	<u>L</u>	oc Code		/			
				FG		80	•						
					3691	80							
•				GA		106							
				12	3899	106							,
				ST315		1251							
					3899	196							, ,
				12	4555	1055					1	• ,	/ /
MS21043-4		Purchased	No			100	Each	1,939.0000	1	3	///	- 2/2	0/2
Nut												2/0	8/0-
				<u>Location</u>		Loc Qty	L	oc Code		,		/ /	
				FG		36							
				10	4603	36							
				GA		2							
				12	1652	2							
	•			ST315		1901							
					1162	. 25							
				12	3021	3							
					23525	29							
					23900	2							
				•	25654	956				₹—			
				m	125807	886							

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Training														
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Unapproved			<u> </u>	<u></u>										
		<u></u>					FAU	JLT CAT	EGORY					
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			ot Concer	itric	$\vdash$	BOM/Route	Н	Grain		<u> </u>	Over/Under		_	et-up
	-	Cracks		//A/	-	Broken/Damage/Defect		Hardwa		, ⊢	Part Incorred			emperature/Cure
	—-		nk/Ripple	/wave	$\vdash$	Burrs			on Incomplete/Unqualifie	) <del></del>	Part Lost/Mi	ssing	_	Veld
	<del></del>	Cuffs			<del> </del>	Contamination	-		ions Incomplete/Unclear		Part Moved		۷	Vrong Stock Pulled
	-	Crushing				Countersink	-	-	ned/off center		Positioned W	•		art.
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		Marks/Ch			-	Drill Holes	${f -}$	Off-set	talthanaki an					
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June-24-13 1:59:26 PM

Work Order ID:	103618								
Parent Item:	D4148-041						Start	Date: 6/24/13	Required Date: 6/24/13
Parent Item Name:	FWD X-TUBE LUC	G ASS'Y					Start	Qty: 1.00	Required Qty: 1.00
D2690-6 Lanyard		Manufactured	No		100	Each	76.0000	<u> </u>	1 5/3/08/23
				<u>Location</u>	Loc Oty		Loc Code		
				ST014	60				
				100513	3				
				101075	12				
				101791	10				
				103055	24			/_	_
				94775	9				_
				95935	1				_
				99808	1				<del></del>
				ST016	16				
				102246	16				- (/,
<b>03910-1</b> Crosstube Lug		Manufactured	No		100	Each	29.0000	1	1. 2/08/2
				<u>Location</u>	Loc Oty		Loc Code		
				ST464	29				_ /
				100342	26				<u>_</u>
				81474	2				- 0 1
				89772	l				- /// /: /
D4091-1 MOUNTING LUG		Manufactured	No		100	Each	41.0000	1	1 2/3/08/0
				Location	Loc Oty		Loc Code		
				ST144	41				
				100346	36				_
				97517	5				
D4148-1		Manufactured	No		100	Each	23.0000	2	2 8/3 /108/2
Crosstube Lug Plate, Fw	⁄d							<del>c</del>	
				<u>Location</u>	Loc Oty		Loc Code		<i>y</i>
				ST145	23				- M 10
				100297	21				M1027711
				85753	2				_

DQA:					WORK ORDER NON-CONFORMANCE / UPDATE									
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					Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering		
Part N	lo				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Therr	moforming	Finishing	Rec/Stor	re/Packaging	Other		
NCR N	lo				Suspected Unapproved	]		Large Fab	Composite	]	Supplier			
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	Centre Not Concentric			BOM/Route		Grain			Over/Under	tolerance	Set-up			
]	Cracks			Broken/Damage/Defect		Hardwa		L	Part Incorred	et	Temperature/Cure			
	Crimp/Kink/Ripple/Wave		_	Burrs		Inspect	ion Incomplete/Unq	ualified	Part Lost/Mi	ssing	Weld			
	Cuffs			Contamination	$\overline{}$	1	tions Incomplete/Un	ıclear	Part Moved	Ĺ	Wrong Stock Pulled			
	Crushing		<u> </u>	Countersink	<u></u>	1	gned/off center		Positioned V	Vrong	<b>-</b>			
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	Marks/	Chatter			Drill Holes		Off-set							
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Wave/Twist in Tube		[	Fit/Function		Out of	Sequence		-						

## June-24-13 1:59:26 PM

Work Order ID: 103618 Required Date: 6/24/13 Parent Item: D4148-041 Start Date: 6/24/13 Parent Item Name: FWD X-TUBE LUG ASS'Y Start Qty: 1.00 -Required Qty: 1.00 D4148-3 100 24.0000 No Each Manufactured Stud Receiver, Lower Location Loc Oty Loc Code ST145 24 100534 20 97610 D4148-5 100 Each 35.0000 Manufactured No Eyebolt Stud Location Loc Qty Loc Code ST145 35 20 100497 102112 12 97587 2 99176 AN3C12A No 100 Each 133,0000 Purchased Bolt Loc Oty Location Loc Code ST351 133 5 123648 126 124561 2 124858 AN4C13A 100 Each 222.0000 No Purchased BOLT Location Loc Qty Loc Code ST356 148 123900 3 45 m125709 m125978 100 ST514 72 72 124805 ST516 2 124215 2

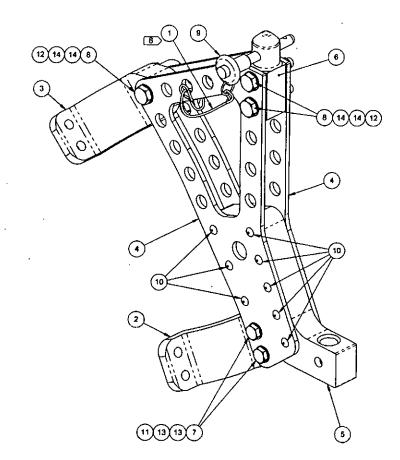
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QA Closed:		Date:		ī					W	ork Order u	odate only	
Work Orde	r:				DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
				_	Rework	1		Skid-tube Crosstube	٦_	1	Water Jet	Engineering
Part N	0.				Scrap			Machining Small Fat	-	Pro	d. Eng. Coor.	Quality
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NCR N	lo.				Suspected Unapproved	1		Large Fab Composite	<u>-</u>		Supplier	
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}	Crimp/Kink/Ripple/Wave Burrs				<u> </u>	1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing	Weld	
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}	Heat Treat Cut Too Short				$\vdash$	Mislabe			Power Loss/	Surge	Other	
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## Picklist Print

June-24-13 1:59:26 PM

Work Order ID:	103618 •									•
Parent Item:	D4148-041							Start E	Date: 6/24/13	Required Date: 6/24/13
Parent Item Name:	FWD X-TUBE LU	JG ASS'Y	*.	:		•		Start	<b>Qty</b> : 1.00	Required Qty: 1.09 /
MS17984-C413 Quick Release Pin		Purchased	No			100	Each	32.0000	1	16/13/18/23
				<u>Location</u>	<u>n</u>	Loc Qty		Loc Code		
				ST332		32				M12625
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					m125827	30				
4S20615-4M18 Livet		Purchased	No	٠.		100	Each	603.0000	8	8 513/08/23
				Location	<u>1</u>	Loc Oty		Loc Code		
				ST312		603				
					125162	97				<del></del>
					125654	506				
NAS1149C0332R WASHER		Purchased	No			100	Each	12,486.000	4	4 5/13/08/2
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				FP001		264		·		
				Ċ	123355	264				<del>-</del> :
				ST292		286				
					123248	18				
					123759	177				<u> </u>
					125268	91				_
				ST511		10000			<del></del>	<del>_</del>
					125654	10000				<del>_</del>
				ST517		1936				- / /
NAS1149C0432R	•	·	31-		124580	1936	<b>.</b>	4 410 0000		-
VASHER		Purchased	No			100	Each	3,418.0000	6	6 5/3/08/2
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		•			m125807	2833		•	<u> </u>	<u> </u>

DQA:		Date:		WORK ORDER NON-CONFORMANCE / UPDATE							TOART	
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / U		Vork Order up	odate only	AEROSPACE
386	<u>-</u>	_			DISPOSITION				•	EPARTMENT,		
Work Orde	er:				Rework	ı		Skid-tube	Crosstube	7	Water Jet	
Part N	lo				Scrap			Machining	Small Fab	- Dro	d. Eng. Coor.	Engineering Quality
TOICE	•0				Use-as-is			noforming	Finishing	<b>—</b>	re/Packaging	Other
NCR N	No.				Suspected Unapproved		,,,,	Large Fab	Composite	- 1100	Supplier	- Julie H
		-				ı				_		
Root			<u> </u>	Desc	ription of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
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	_	Not Conce	ntric	 	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	F-	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorred	<u> </u>	Temperature/Cure
				Burrs	L	1 '	ion Incomplete/Ur	· -	Part Lost/Mi	ssing	Weld	
	<b>├</b>			Contamination	<u> </u>	4	ions Incomplete/L	Jnclear	Part Moved	L	Wrong Stock Pulled	
Crushing Countersink				_	1	ned/off center	 	Positioned V	_	¬		
Heat Treat Cut Too Short			4		Mislabe		L	Power Loss/	Surge	Other		
Inspection Strip in Tube Drawing			=	<u> </u>	Misread	t		-				
	_	/Chatter		<u> </u>	Drill Holes	$\vdash$	Off-set			<del></del>		
		g Sequence		<u> </u>	Finish	$\vdash$	-	Calibration				
Wave/Twist in Tube				Fit/Function		Out of !	Sequence					



## **D4148-041 FWD X-TUBE LUG ASSY**

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
7) WEIGHT: 3.66 lbs
8) ATTACH D2680-8 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

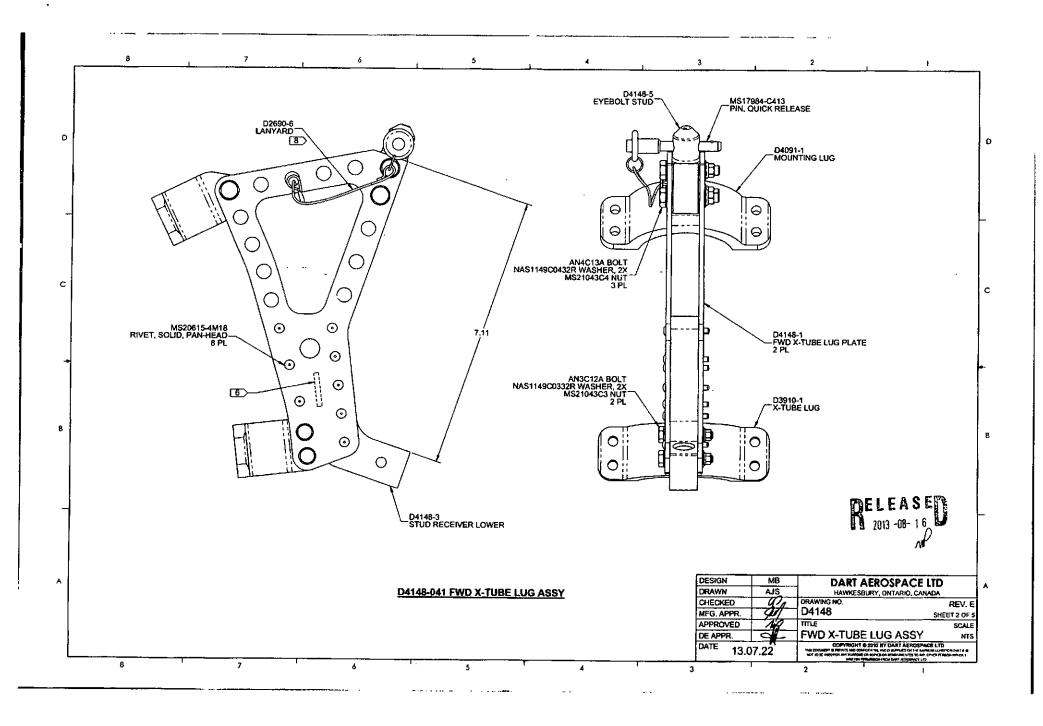
ITEM	-041	P/N	DESCRIPTION
	Х	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIN, QUICK RELEASE
10	В	MS20615-4M18	RIVET, SOLID, PAN-HEAD
11	2	MS21043C3	NUT, SELF-LOCKING
12	3	MS21043C4	NUT, SELF-LOCKING
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER



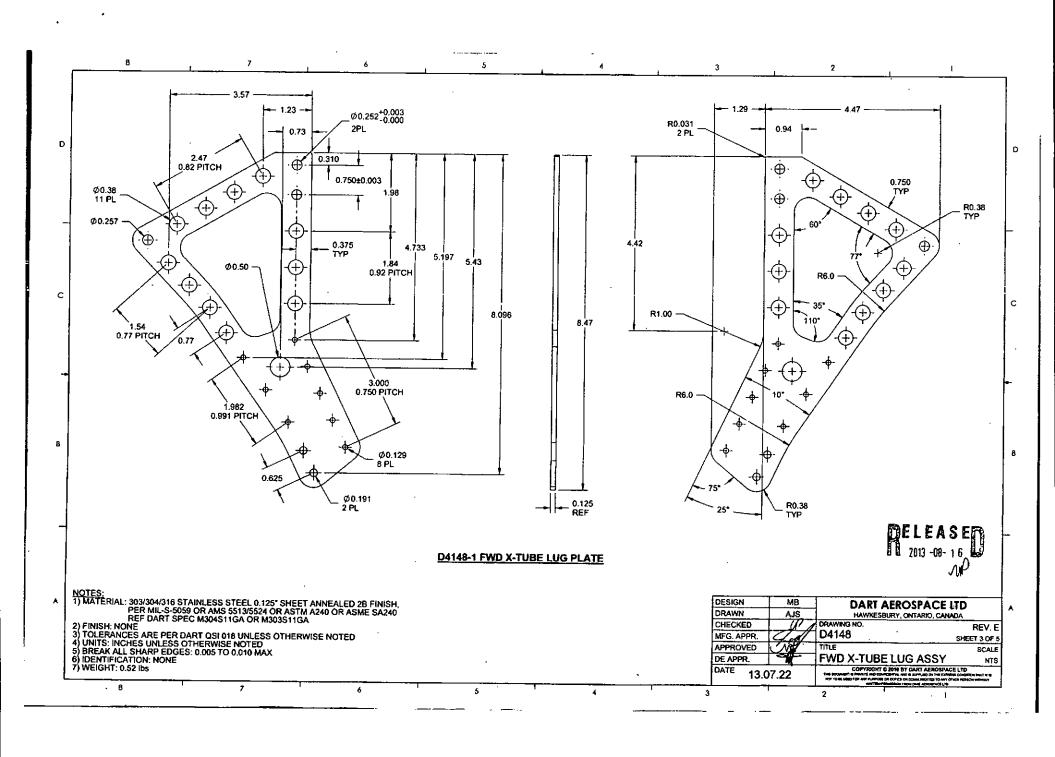
C

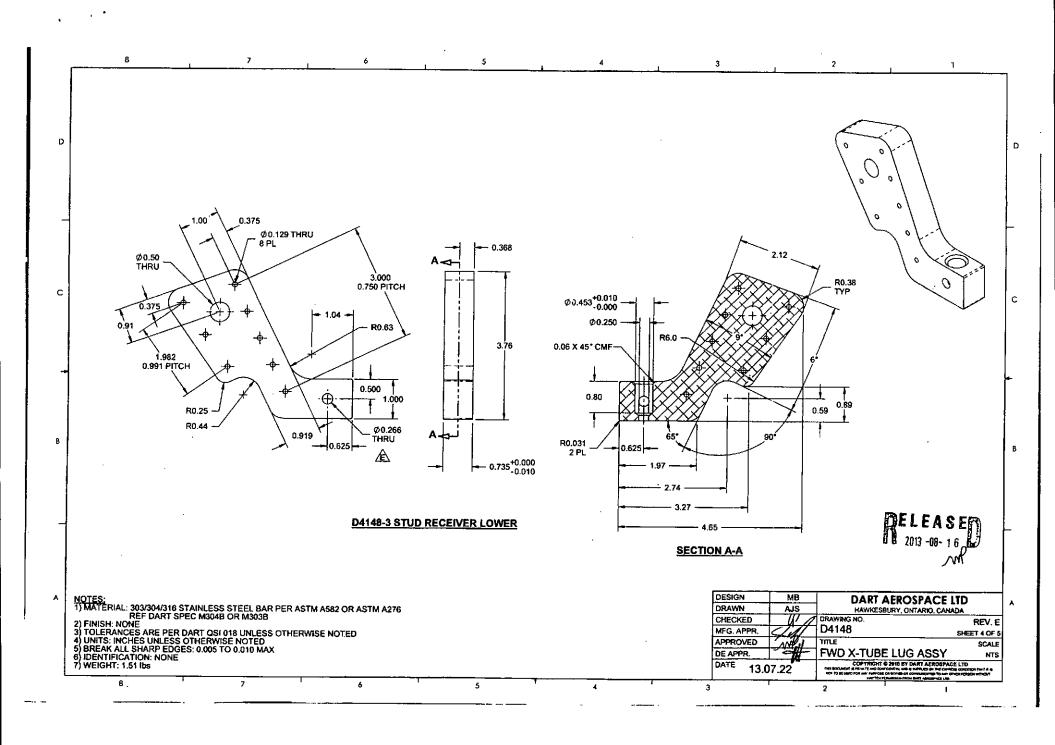
E	B5-4 Ø INSTAL	0.266 HOLE AC	DDED FOR CARGO TUBE	AJS	13.07.22
D	MS210	IED TO 0.250° 1303 AND OTY 3A. MS210430	TO 0.252" (D6-3); HOLE DIA C8-5); REPLACED QTY(2) AN3C1: (4) NAS1149C0332R WITH QTY(2) (4) NAS1149C0432R (D	l BC	11.02.22
С	REDES ISSUES	IGNED D4148- WITH D350-59	1/-3 TO ADDRESS COMPATIBILITY OI SHORT STEPS	MB	10.10.12
В	MASH2 MS208 Ø0.129	2A, MS21043-3 R (ZN D3-1, B7 IS-4M20 (ZN D3 3 PL (ZN D6-3	520613-4M18 WITH QTY(2) EACH AND QTY(4) NAS1149C0337R -2 & B4-2), MS20615-4M18 WAS L-1 & B7-2); Ø0.191 Z PL REPLACE I; Ø0.129 J PL WAS 10 PL (ZN A7- N C8-5). 0-607-2 REV. B.	S MB	10 07.05
_ ^	NEW IS	SUE		МВ	10.06.18
REV.		*	DESCRIPTION	BY	DATE
DESIGN	4	MB	DART AERO	SPACEL	TD
DRAWN	a	AJŞ	HAWKESBURY, ON		
CHECK	ED	41	DRAWING NO.		REV. E
MFG. A	PPR.	1.4	D4148		SHEET 1 OF 5
APPRO	VED	ZNV	TITLE		SCALE
DE APP	R.	-41	FWD X-TUBE LUG	ASSY	NTS
DATE	13.0	7.22	COPYRIGHT © 2019 BY C	BATTO PO ON THE ENTER!	000000 0+164

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